

Date: Tuesday, 11/29/2005 11:23:53 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : CLAMP
<b>Job Number</b> : 24979	
<b>Estimate Number</b> : 10584	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D1048
<b>This Issue</b> : 11/29/2005 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D1048 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 24986	<b>Material</b> : N/A
<b>Written By</b> : SEE COMMENT BELOW	<b>Due Date</b> : 12/19/2005
<b>Checked &amp; Approved By</b> : SEE COMMENT BELOW	<b>Qty</b> : 50 <b>Um</b> : Each
<b>Comment</b> : Est: B 02.02.22 Re-format NG	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: 2000000184 20511129

Stamp and deburr per dwg D1048

Material: Stainless steel T304#2B Supply release not for Material.

2.0	D1048F	Clamp
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**Comment:** Qty.: 1.0000 U(s)/Unit Total: 50.0000 U(s)

CLAMP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

C206101105

50

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

06-01-17 50

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.

2-Form as per dwg D2010 using DT8053

SAD 06-01-21

FF 06-01-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 11/29/2005 11:23:53 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 24979

Part Number: D1048

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



206.01.25

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

ml 06 02 08

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C206102107

(50)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 11

C206102107

(50)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUE 06/02/08

(50)

SP 06/02/08

50

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: 2D Date: 06/02/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED  
97/09/02 RCL

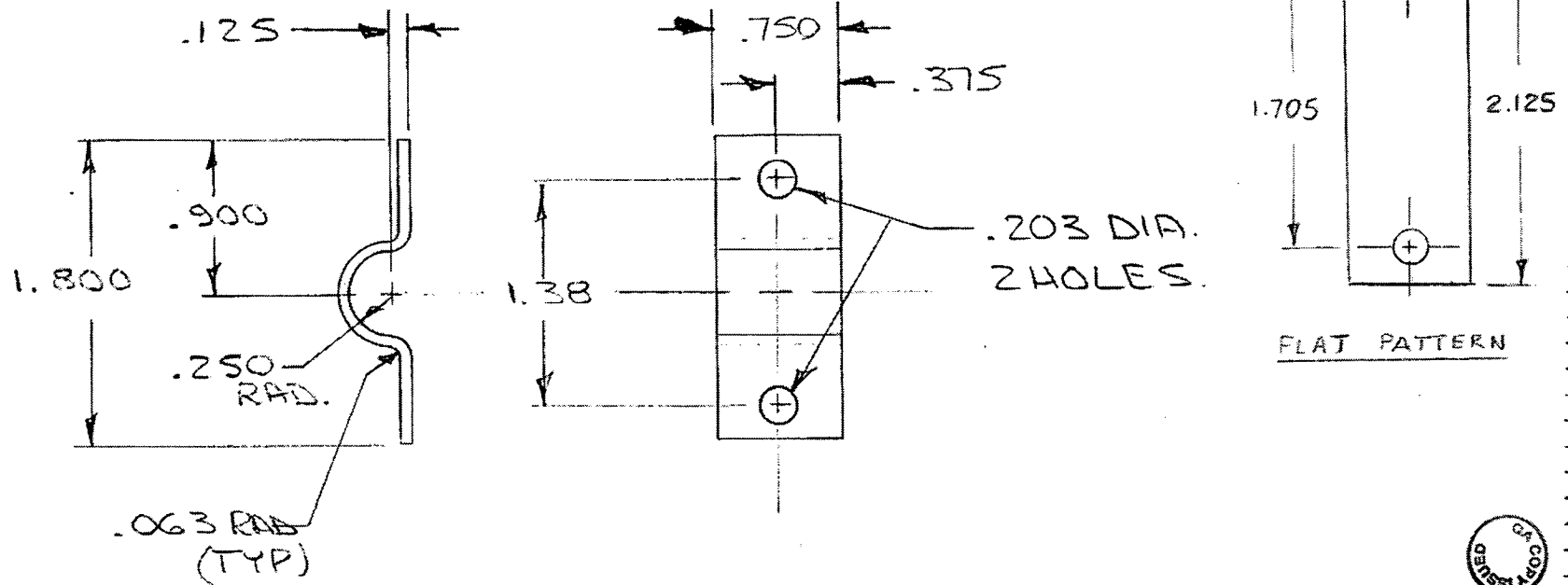
NOTES:

1) MATERIAL

STAINLESS STEEL  
T304#2B .062 THICK

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)  
PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



01.12.05 ADD FLAT PATTERN	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER MAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
	DRAWN		BASIC CODE	DIA. DASH NO. H=HEAD NEAR SIDE T=HEAD FAR SIDE	CONTRACT NO.		DART AERO ACCESSORIES INC. VANCOUVER CANADA		
	APPROVED		Q=QUANTITY D=DISTANCE OF SHEETS C=COUNTERSINK	LENGTH DASH NO. W=SPOTWELD	DRAWN BRADLEY	DATE 5/1/91			
	DESCRIPTION OF CHANGE		BASIC CODES S=SPRINGS B=STITCHING		DESIGN BRADLEY				
REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISH SHALL BE 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL. S. 3742 5. HOLES PER MIL 10387		TOLERANCES — UNLESS OTHERWISE SPECIFIED FINISH 1. TOLERANCES — .001 & .002 2. ANGLES 1/2° 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX. 5. SYMMETRY ABOUT ALL SURF. CENTRE LINES .005		TITLE CLAMP		CODE D1048		REV. A	
REPORT ALL DISCREPANCIES — DO NOT SCALE									
					2		1		

90250188

## INSPECTION CERTIFICATE

### MATERIAL TEST/INSPECTION CERTIFICATES

**YEH MAU CORP.**

INVOICE NO.:  
COMMODITY:

FORM 471  
PICKED COLD ROLLED STAINLESS STEEL SHEET ANSI 304/304M (304)  
FINISH WITH 100 MIC. FILM ON MAIN SIDE, WITH BACK FINISH,  
SLITTED EDGE AND 304/304 FINISH WITH PAPER INTERLEAVED,  
SLITTED EDGE.

SPECIFICATION:  
CUSTOMER:

ANR 304  
INTEGRIS METALS LTD

工廠:高雄縣路竹鄉廣安路345號  
345, SHUN AN RD., LU CHU HSIANG  
KAOHSIUNG TAIWAN R.O.C.  
TEL: (87) 8672005 FAX: (87) 8672008  
CERTIFICATE NO: 90250188  
DATE OF ISSUE: 06/19/2004

(ITEM NO) SIZE	NO.	Weight (L.W.)		Heat No.	ID NO.	Physical Properties Tensile Test CL=50 mm					Chemical Composition (%)								
						YS	TS	EL	HRB	HV	C	SI	Mn	P	S	Ni	Cr	N	
		KGS	LBS			(Min)	(Min)	(%)			x100	x100	x100	x1000	x1000	x100	x100	x100	
ANSI 304 2B (7425-4228) 12GA/48"X120" (7425-5551)	1	1,473	3,247	YU132583	34321644B-4	265	808	58	81	150	3.9	49	115	24	4	807	1827	3.2	
12GA/48"X120" (7425-5510)	1	1,445	3,186	YU228949	34321939B-5	280	800	57	80	150	4.2	48	118	24	5	828	1828	2.8	
12GA/48"X120" (7425-5894)	1	1,457	3,212	YU228245	35522525A-3	285	835	54	82	150	4.5	48	126	30	3	815	1827	2.5	
12GA/48"X120" (7425-5894)	1	1,435	3,164	YU131655	35522522A-2	312	884	54	83	163	4.5	48	107	32	7	812	1834	2.2	
12GA/48"X120" (7425-5893)	1	1,435	3,164	YU131633	35522522A-3	312	884	54	83	163	4.5	48	107	32	7	812	1834	2.2	
12GA/48"X120" (7425-5893)	1	1,414	3,117	YU131655	35522522A-4	312	884	54	83	163	4.5	48	107	32	7	812	1834	2.2	
12GA/48"X120" (7425-5893)	1	1,480	3,283	YU228028	35523008A-4	277	835	54	77	145	4	47	112	28	4	821	1815	2.8	
12GA/48"X120" (7425-5877)	1	1,437	3,168	YU229031	35522903C-5	296	800	53	82	150	4.2	49	114	32	5	810	1813	1.7	
12GA/48"X120" (7425-5460)	1	1,430	3,153	YU132680	35523001B-11	281	837	55	80	154	4.4	50	113	30	5	801	1811	2.8	
12GA/48"X120" (7425-5460)	1	1,430	3,153	YU132680	35523001B-9	281	837	55	80	154	4.4	50	113	30	5	801	1811	2.8	
12GA/48"X120" (7427-3541)	1	1,391	3,067	YU132680	35523001B-12	281	837	55	80	154	4.4	50	113	30	5	801	1811	2.8	
12GA/48"X120" (7427-3590)	1	1,465	3,230	YU228945	35523007A-12	308	855	53	83	165	4.9	45	108	24	5	817	1824	3.1	
12GA/48"X120"	1	1,371	3,023	YU228945	35523007A-13	308	855	53	83	165	4.9	45	108	24	5	817	1824	3.1	
12GA/48"X120"	1	1,375	3,031	YU228945	35523007A-14	308	855	53	83	165	4.9	45	108	24	5	817	1824	3.1	
12GA/48"X120" (7427-4327)	1	1,375	3,031	YU228945	35523007A-15	308	855	53	83	165	4.9	45	108	24	5	817	1824	3.1	
12GA/48"X120"	1	1,423	3,137	YU132689	35523083A-11	284	848	53	82	161	5.2	51	115	31	3	802	1823	2.8	
16		22,336	50,346																
NO MERCURY CONTAMINATION		Bond not good for all Heat NO.																	
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN MEETS ALL																			

NO MERCURY CONTRIBUTION  
GENERALLY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS  
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

Product in accordance with ASTM A240, A480,  
A302, ASME SA240, Q35788D.

YEH MAU CORP.

*Lin Kun Hsiung*  
Manager of Quality Assurance Section

1694 304 #4  
#26 Finish ✓  
206-01-17

1004 186 154 1416